

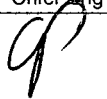






W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

CAR 10-21

Part No: D3281-3208 PAR #: \_\_\_\_\_ Fault Category: eng-drawing NCR: Yes ☒ No ☐ DQA: ✓ Date: 10/09/07

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>61365</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.08.27	B30	Part narrower by 2 1/8"	 10.08.27 Q5/07L	- Acceptable. - Dwg ERROR See CAR 10-21 ✓	 10/08/07	 10/08/20 Q5/04L	 10.08.27 Q5/04L	 10/08/30

NOTE: Date &amp; initial all entries

**Work Order ID 61365**

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Page 2

Item ID: D3281-3L08

Accept

Setup Start

Revision ID:

Stop

Item Name: Floor Protector, Aft LH

Start Date: 8/19/2010 Start Qty: 3.00

Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 3.00




Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110  Thermoform Thermoforming Machine	THERMOFORMING MACHINE  Memo Thermoform as per Dwg. D3281 and Folio FTA 009 Dwg. Rev. <u>E</u> Folio Rev. <u>D</u>	0.00  0.00							<u>1.4</u> (X3) <u>10/08/25</u>
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00							<u>1.4</u> (X3) <u>10/08/25</u>
130  Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING  Memo Trim to Finished Dimensions	0.00  0.00							<u>1.4</u> (X3) <u>10/08/25</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61365**

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Page 3

Item ID: D3281-3L08

Accept

Setup Start

Revision ID:

Stop

Item Name: Floor Protector, Aft LH

Start Date: 8/19/2010 Start Qty: 3.00

Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 3.00

Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00				<u>10/28/25</u>	<u>10/08/25</u>		
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		<u>8.10.08/30</u>		<u>(X3)</u>			
160  Packaging Packaging	Packaging  Memo	0.00  0.00		<u>PP 61362</u>		<u>10/18/25</u>	<u>30</u>		

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61365**

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Page 4

Item ID: D3281-3L08

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Aft LH

Start Date: 8/19/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

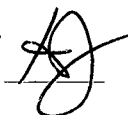


QC

Memo

0.00

Quality Control

10/08/31   
CL 10/08/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, August 19, 2010 1:57:42 PM

Page 1

Work Order ID: 61365

Parent Item: D3281-3L08

Parent Item Name: Floor Protector, Aft LH

Start Date: 8/19/2010


Required Date: 8/25/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev. A 10.02.24 New Issue LL  
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev, B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	2,563.470	5	15.78947			
													

Lexan Sheet

Location

therm

Loc Qty

2563.47

2563.47

Loc Code

113127

15 sq ft. Pl. 10/00/25

9.35

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Floor Protector, Aft LH		<b>Part Number:</b>	D3281-3
<b>Inspection Dwg:</b> D3281	<b>Rev:</b> <i>DE IR</i>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article    ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	<input checked="" type="checkbox"/>			
Shape Definition	<input checked="" type="checkbox"/>			
Texture Retention	<input checked="" type="checkbox"/>			
Material imperfections such as bumps, cracks, voids, scratching				

**Measured by:** *Wk*      **Date:** *10/08/25*

#### TRIMMING SECTION

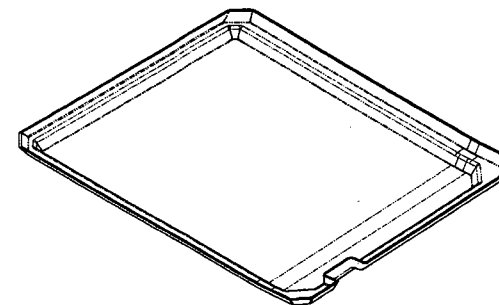
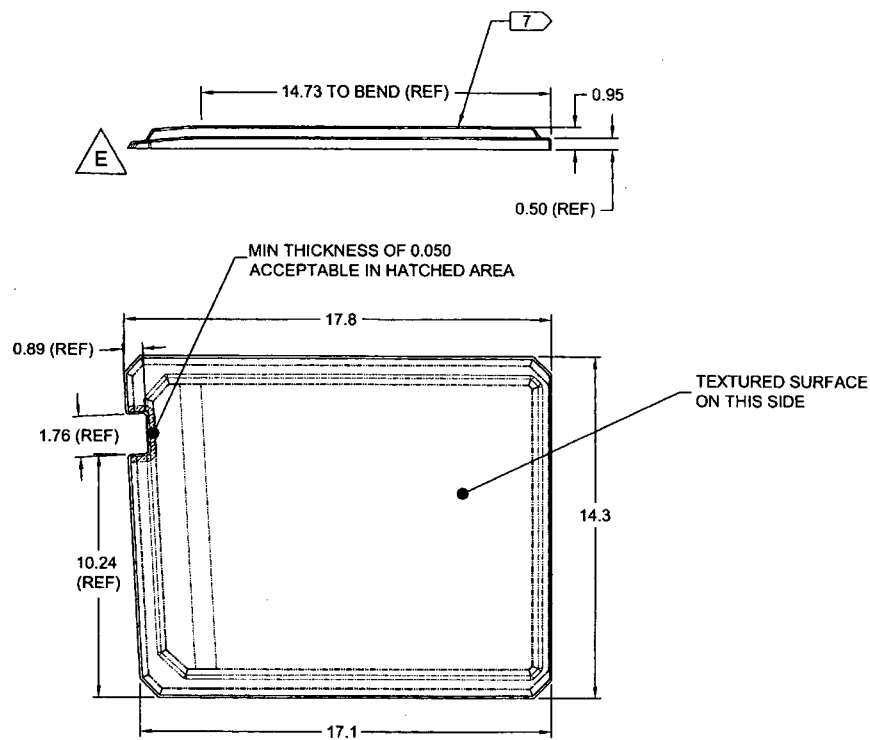
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	<i>17.06</i>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		<i>SEE NCR Pg 1.</i>
17.1	+/-0.100	<i>17.00</i>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		
14.3	+/-0.100	<i>14.250</i>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		
0.95	+/-0.030	<i>0.957</i>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		
<del>0.25</del>	<del>+/-0.030</del>	<i>N/A</i>				
<del>3.1</del>	<del>+/-0.100</del>	<i>N/A</i>				
0.050	Min	<i>0.077</i>	<input checked="" type="checkbox"/>			
0.070	Min	<i>0.087</i>	<input checked="" type="checkbox"/>			

**Measured by:** *Wk*      **Date:** *10/08/25*

**Audited by:** *BB*      **Date:** *10/08/27*

**Prototype Approval:** N/A      **Date:** N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	08.09.12	Tolerance revised for 0.070 dimension	KJ/DL <i>AF</i>	<i>DD</i>



# 61365

DEO ATTACHED

RELEASED  
2010-02-03

# **D3281-3 FLOOR PROTECTOR**

## **D3281-3 NOTES:**

- 1) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3281	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
DATE	10.01.05	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DRAWING NO. D3281	TITLE FLOOR PROTECTOR	REV. E	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3281-E-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>K</i>	MFG. APPR. <i>DL</i>	APPROVED <i>#</i>	DE APPR. <i>#</i>		
DATE 10.02.24	DATE 10.02.25	DATE 10/02/25	DATE 10.02.25	DATE 10.02.25	DATE 10.02.25	

# **PURPOSE**

ADD "D3281-xL08" MATERIAL OPTION. EXISTING PARTS TO BE IDENTIFIED AS "D3281-xL02"

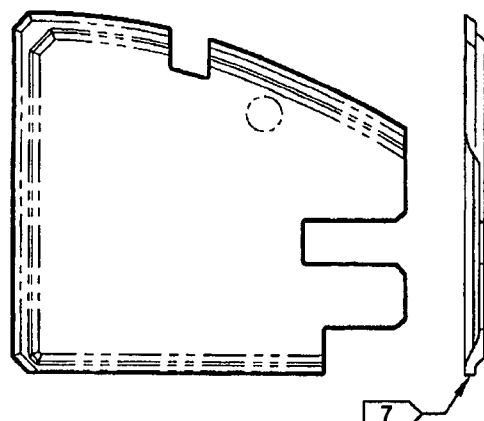
# **CHANGE**

D3281-xL08 PARTS ARE EQUIVALENT TO THE RESPECTIVE "-x" PARTS EXCEPT AS DETAIL BELOW. THE MATERIAL, IDENTIFICATION, AND WEIGHT NOTES ARE AMENDED AS FOLLOWS:

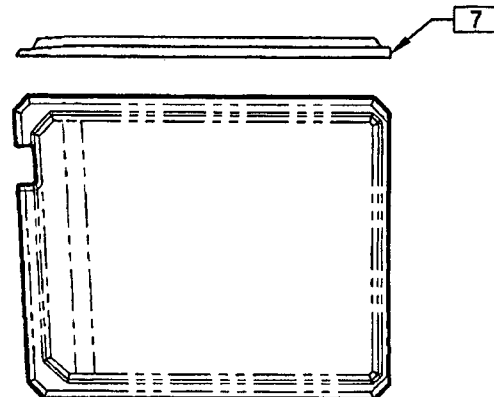
- 2) MATERIAL: -xL02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)  
-xL08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)

- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-xLxx" AND B/N "Bxxxx" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS.  
FOR -xL08 PARTS, LOCATE ENGRAVING ALONG PERIMETER OF PART AS SHOWN.

- 8) WEIGHT: D3281-1L02/-2L02 = 0.95 lb D3281-1L08/-2L08 = 1.13 lb  
D3281-1L02/-2L02 = 0.87 lb D3281-3L08/-4L08 = 1.05 lb



**D3281-1L08 FLOOR PROTECTOR (SHOWN)**  
**D3281-2L08 FLOOR PRETECTOR (OPPOSITE)**  
LOCATION OF ENGRAVING



**D3281-3L08 FLOOR PROTECTOR (SHOWN)**  
**D3281-4L08 FLOOR PRETECTOR (OPPOSITE)**  
LOCATION OF ENGRAVING

**RELEASED**  
2010-02-26  
*MD*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries